

Date: Thursday, 14/08/2008 8:32:26 AM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : INSTRUMENT PANEL WELDMENT
 Job Number : 41227
 Estimate Number : 13167
 P.O. Number :
 This Issue : 14/08/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : R & D LG FAB
 Previous Run : 37302
 Part Number : D3705043
 Drawing Number : D3705 *PROTO 08.08.14 Rev.B*
 Project Number : N/A
 Drawing Revision : PROTO
 Material :
 Due Date : 15/08/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : *MF 08-08-14*
 Comment : Est Rev:A new issue 08-05-30 DD verified by:ec

PRELIMINARY ISSUE*08.08.14*

Additional Product

PROTOTYPEPOSITIVE
RECALL

Job Number:



FOR ENGINEERING USE ONLY

Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Pick Packing Kit	
2.0	D37051	MAIN PANEL
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) MAIN PANEL batch <i>B41225</i>	
3.0	D37053	COVER PLATE
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) COVER PLATE batch <i>B41226</i>	
4.0	D37061	Lock Bracket
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Lock Bracket batch <i>B05023</i>	
5.0	D37063	Guide
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Guide batch <i>B05022</i>	

*PD 08-08-15**PD 08-08-15**05023**PD 08-08-15**05022**PD 08-08-15*

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Job Number: 41227

Part Number: D3705043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble and weld as per dwg D3705 per QSI004

*****nice weld all around and buff weld smooth****

Aluminum rod batch: M106330

PD 08-08-15 ①

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/08/15 ①

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-08-15

**ENGINEERING
APPROVAL**

08-08-20 ①

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08-08-15 ①

PTO

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M102316

1X

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:00
320 °F
1:30

M-A 08/08/14

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-19 ①

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FOR ENGINEERING USE ONLY

09.01.26

✓

9.1 ~~Chemical coat~~ QC 3 inspection

9.2 MS20426A D3-3 Rivet lot# H1563

9.3 QTY 28

FF 08-08-18 ①

MS20752 3 nut plate lot# H108751

QTY 14

FF 08-08-18 ①

9.4 install rivet and nut plate

FF 08-08-19 ①

9.5 QCS

FF 08-08-19 ②

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13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/17



10.08.22 Prototype

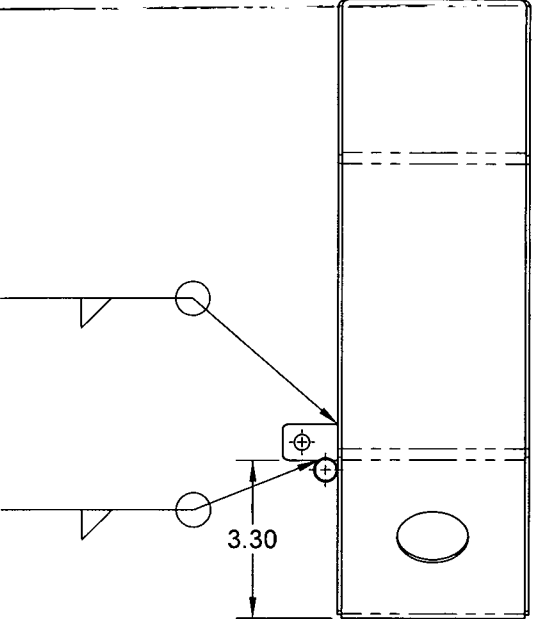
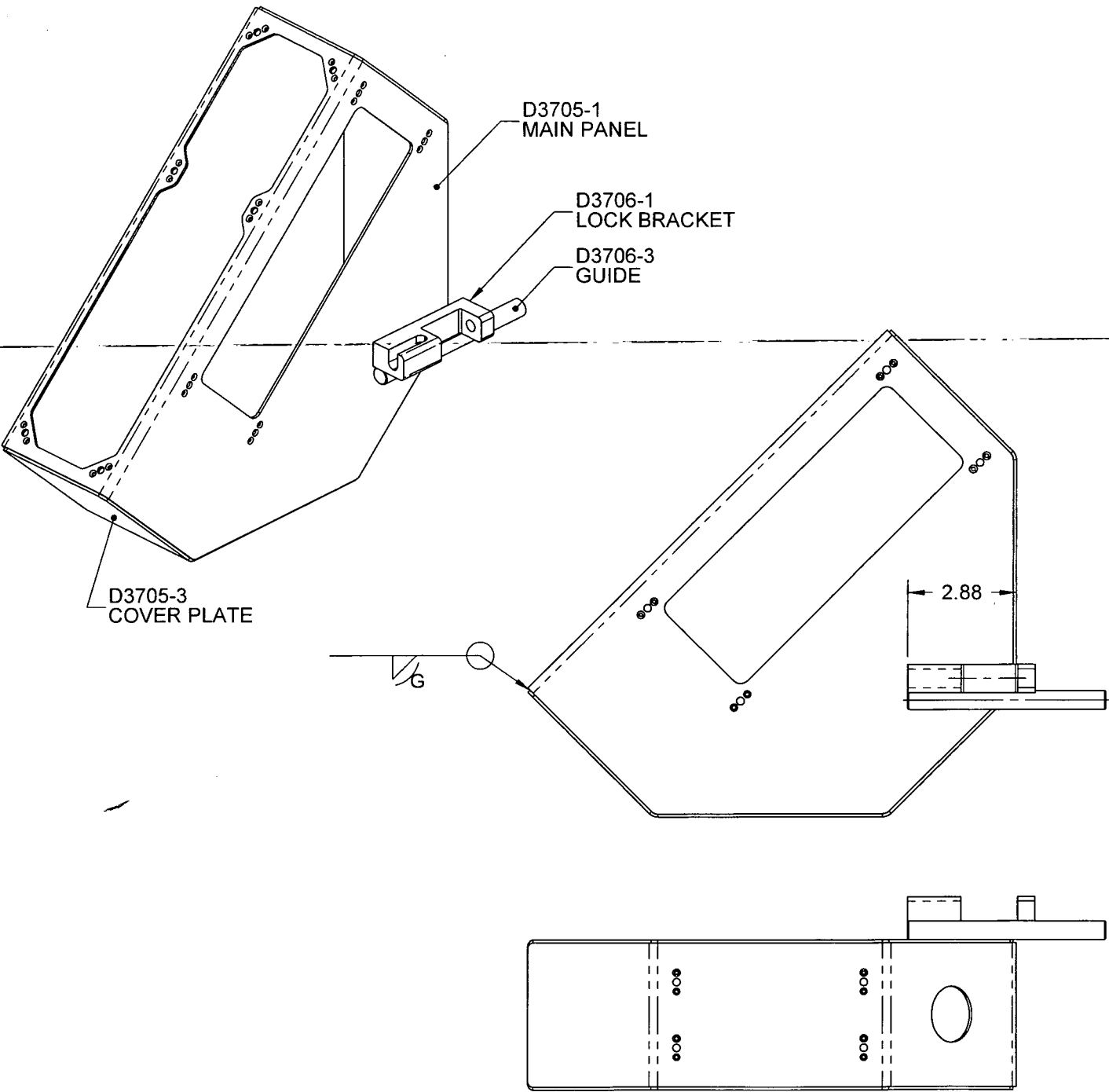
Job Completion



u 09.01.26

POSITIVE RECALL
EFFECTIVE 06.08.22 AUTH u
RELEASED 1 DATE 06.02.12

-043 QTY.	P/N	DESCRIPTION
X	D3705-043	INSTRUMENT PANEL WELDMENT
1	D3705-1	MAIN PANEL
1	D3705-3	COVER PLATE
1	D3706-1	LOCK BRACKET
1	D3706-3	GUIDE



D3705-043 INSTRUMENT PANEL WELDMENT

- D3705-043 NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.90 lbs
 - 8) WELDING: PER DART QSI 004

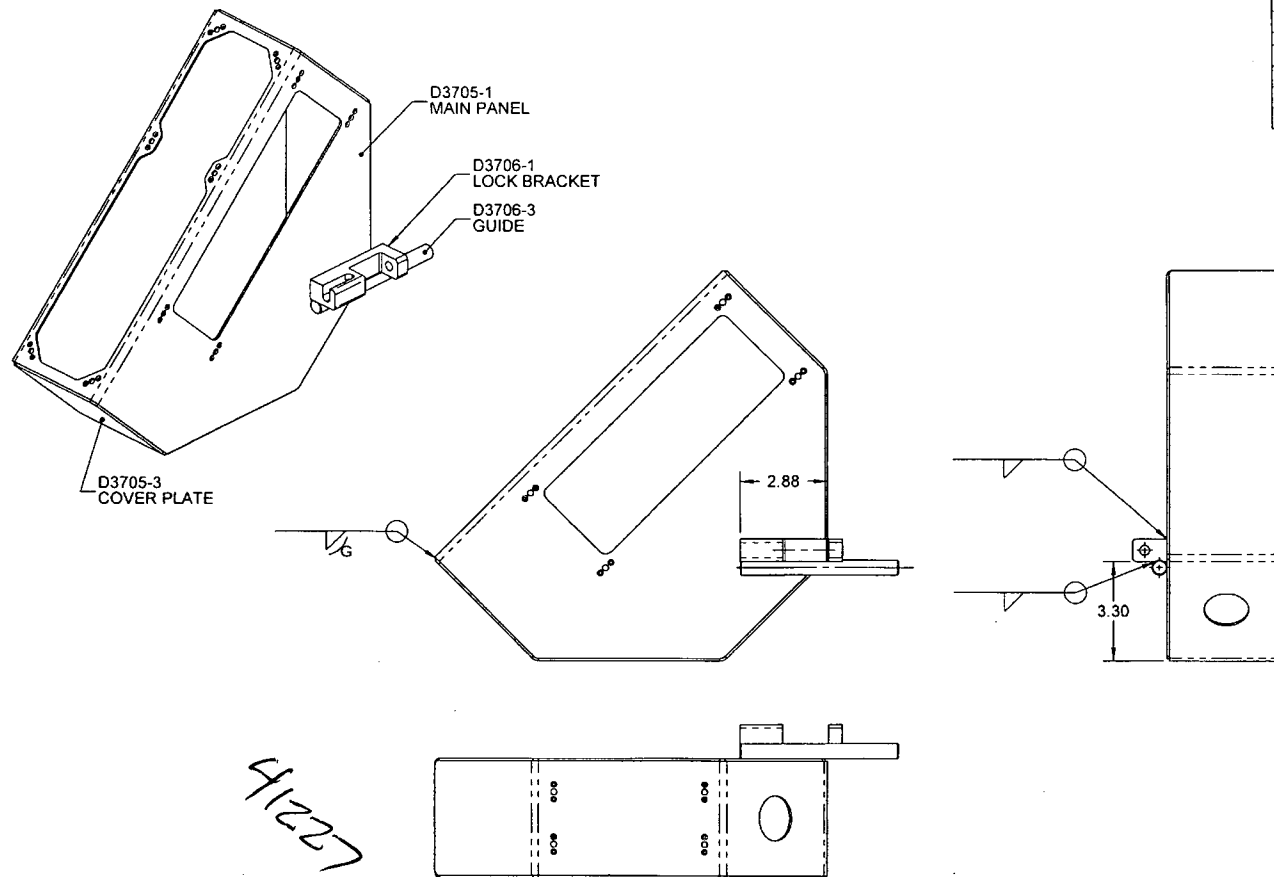
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3705	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		INSTRUMENT PANEL ASS'Y	NTS
DATE	08.08.07	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

PRELIMINARY ISSUE
08.08.22

PROTOTYPE
08.08.14

41227

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UNDER REVIEW
08.01.14

RELEASED
09/01/14

DESIGN	WIP FOR MB	DART AEROSPACE LTD	
DRAWN	WIP FOR MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RA	DRAWING NO.	REV. B
MFG. APPR.	WIP FOR MB	D3705	SHEET 2 OF 5
APPROVED	WIP FOR MB	TITLE	SCALE
DE APPR.	WIP FOR MB	INSTRUMENT PANEL ASS'Y	NTS
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